

Work Order ID 151637

Tuesday, October 04, 2016 1:07:18 PM

151637

Page 1

Item ID: D3788-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Cabin Floor Protectors

Start Date: 10/4/2016 Start Qty: 4.00

4

Cust Item ID:

Required Date: 10/18/2016 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: **DAS**
21 Date: **OCT 04 2016**
QC: **9-89** Date:

Tooling:

Date:

SPC (Y/N):

Date:

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3788	Rev A								

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.31

FLOW CNC Waterjet

1-Cut as per Dwg D3788 Dwg Rev: **A** Prog Rev: **A** 2-
Deburr if necessary**(4)****Oct 16 / 10 / 09**

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.01

Quality Control

(4)**Oct 16 / 10 / 09**

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.01

Quality Control

(4)**DAS**
38
9-89**OCT 12 2016**

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER :					

Tuesday, October 04, 2016 1:07:18 PM

Page 2

Accept

Setup Start

NS1

Stop ***NS2***

4

4

Reference:

Run Start *NR1*

Stop *NR2*

**Insp.
Stamp**

0.00

0.01

4-

DAS
6
~~9-8.9~~

OCT 12 2016

0.00

0.07

DAS
21
9-88

OCT 13 2016

DAS
21
9-89

OCT 12 2016

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Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER : _____			
Misidentified	☐	Past Due	☐				

Picklist Print

Tuesday, October 04, 2016 1:07:21 PM

Work Order ID: 151637

151637

Parent Item: D3788-1

D3788-1

Parent Item Name: Cabin Floor Protectors

Start Date: 10/4/2016

Required Date: 10/18/2016

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev :A 08-08-20 New Issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.125-F60029-04		Purchased	No			100	sf	1,860.902	21.3	100.2353			

MI FXS 125-F60029-04

GE PLASTICS LEXAN SHEET (DARK GREY)

2-16/10/09

Location

Loc Qty

Loc Code

MAT018

1860.902353

m135074

1860.90235

100

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



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Design ☐		Operator ☐		Bending ☐		Set-up ☐	
Doc/Data ☐		Offset/Setup ☐		Centre Not Concentric ☐		BOM/Route ☐	
Equip/Tooling ☐		Supplier ☐		Cracks ☐		Broken/Damage/Defect ☐	
Handling/Pre ☐		Training ☐		Crimp/Kink/Ripple/Wave ☐		Inspection Incomplete/Unqualified ☐	
Material ☐		Use for Testing ☐		Cuffs ☐		Contamination ☐	
Internal Transport ☐		Poor Information ☐		Crushing ☐		Countersink ☐	
Tribal Knowledge ☐		Rushing ☐		Heat Treat ☐		Cut Too Short ☐	
LOA ☐		Product Improvement ☐		Wave/Twist in Tube ☐		Instructions Incomplete/Unclear ☐	
Substation ☐		Process Improvement ☐		Marks/Chatter ☐		Drill Holes ☐	
Past Expiry Date ☐		Manufacturing Process ☐		OTHER : _____			
Misidentified ☐		Past Due ☐					

DQA: _____ Date: _____

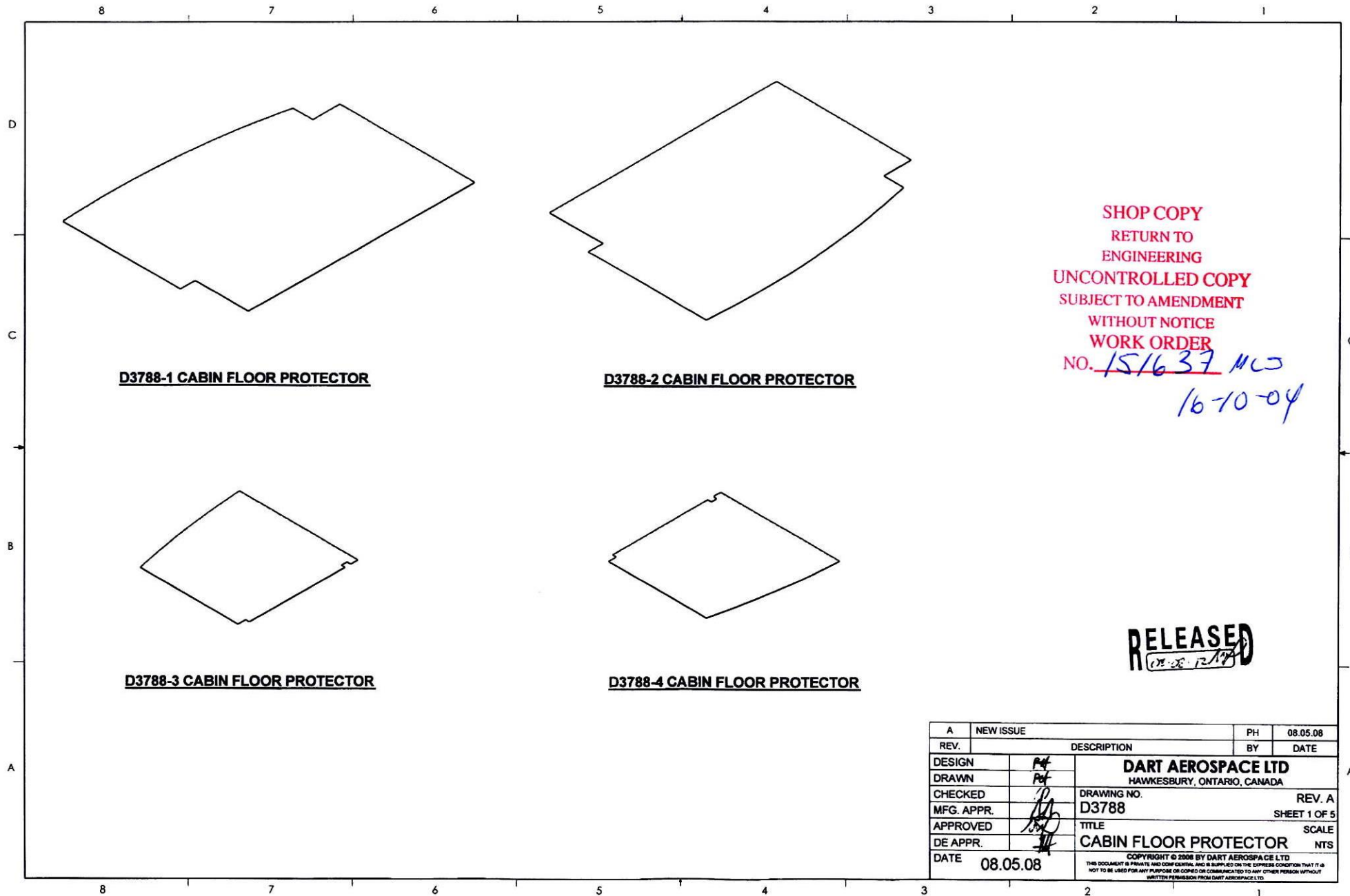
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		OTHER : ☐							



D3788-1 CABIN FLOOR PROTECTOR

D3788-2 CABIN FLOOR PROTECTOR

D3788-3 CABIN FLOOR PROTECTOR

D3788-4 CABIN FLOOR PROTECTOR

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 151637 MLC
16-10-04

RELEASED
(18-08-12/19)

A	NEW ISSUE	PH	08.05.08
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>Pat</i>		
DRAWN	<i>Pat</i>		
CHECKED	<i>P</i>		
MFG. APPR.	<i>AB</i>		
APPROVED	<i>AB</i>		
DE APPR.	<i>AB</i>		
DATE	08.05.08		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		REV. A	
DRAWING NO. D3788		SHEET 1 OF 5	
TITLE		SCALE	
CABIN FLOOR PROTECTOR		NTS	
COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD			

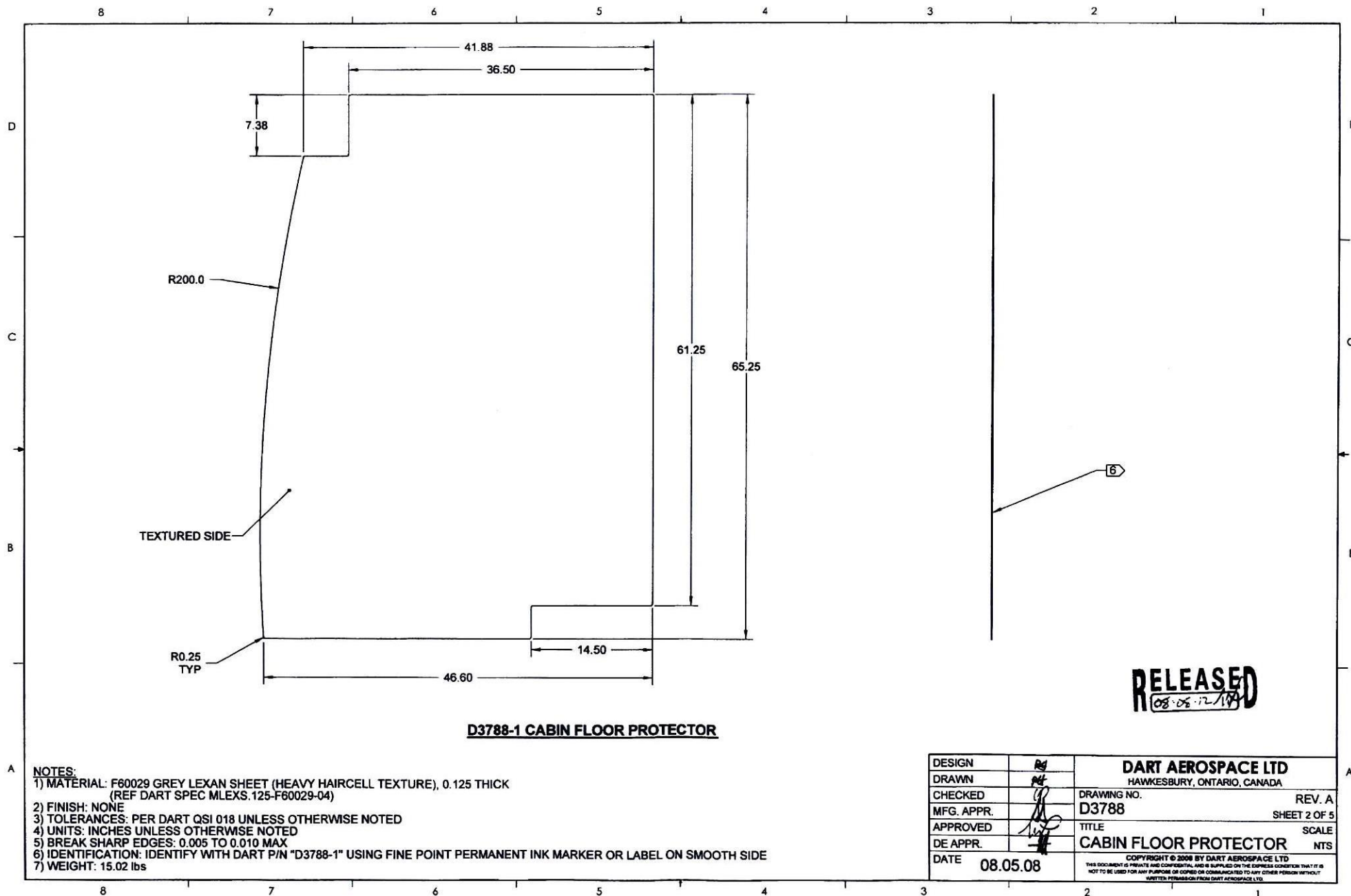
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		OTHER : _____							



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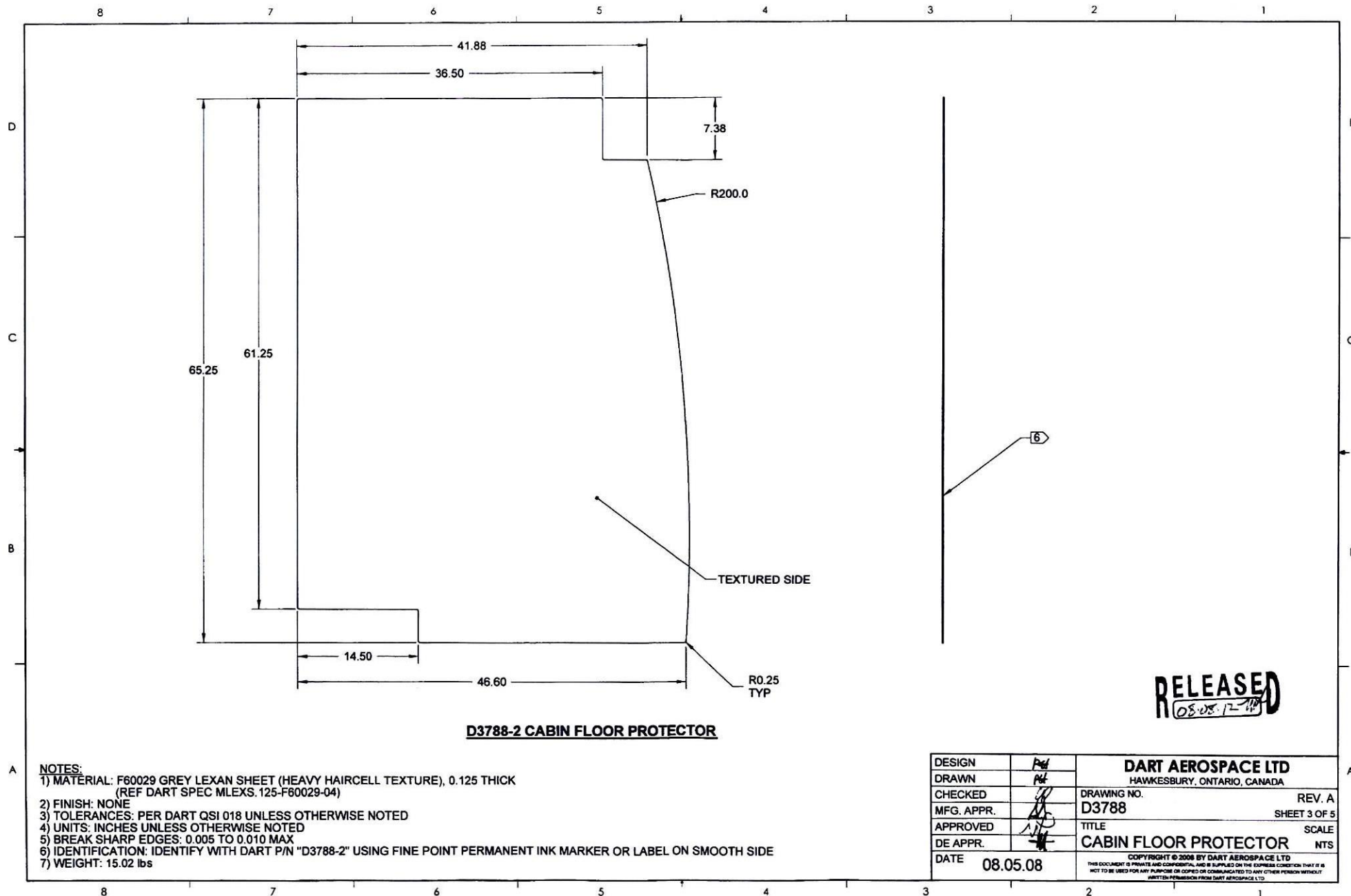
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Misidentified ☐	Past Due ☐																																																																



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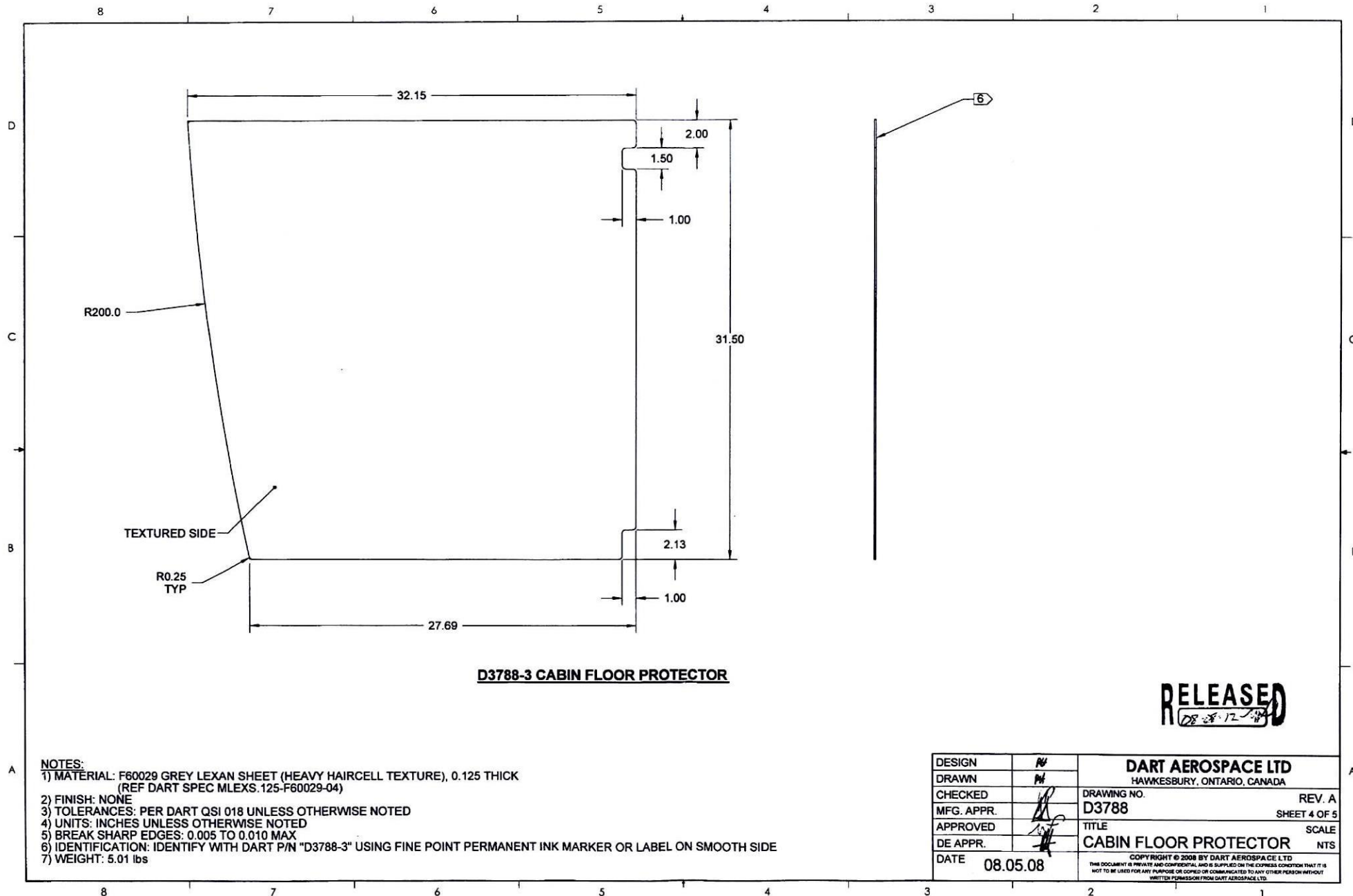
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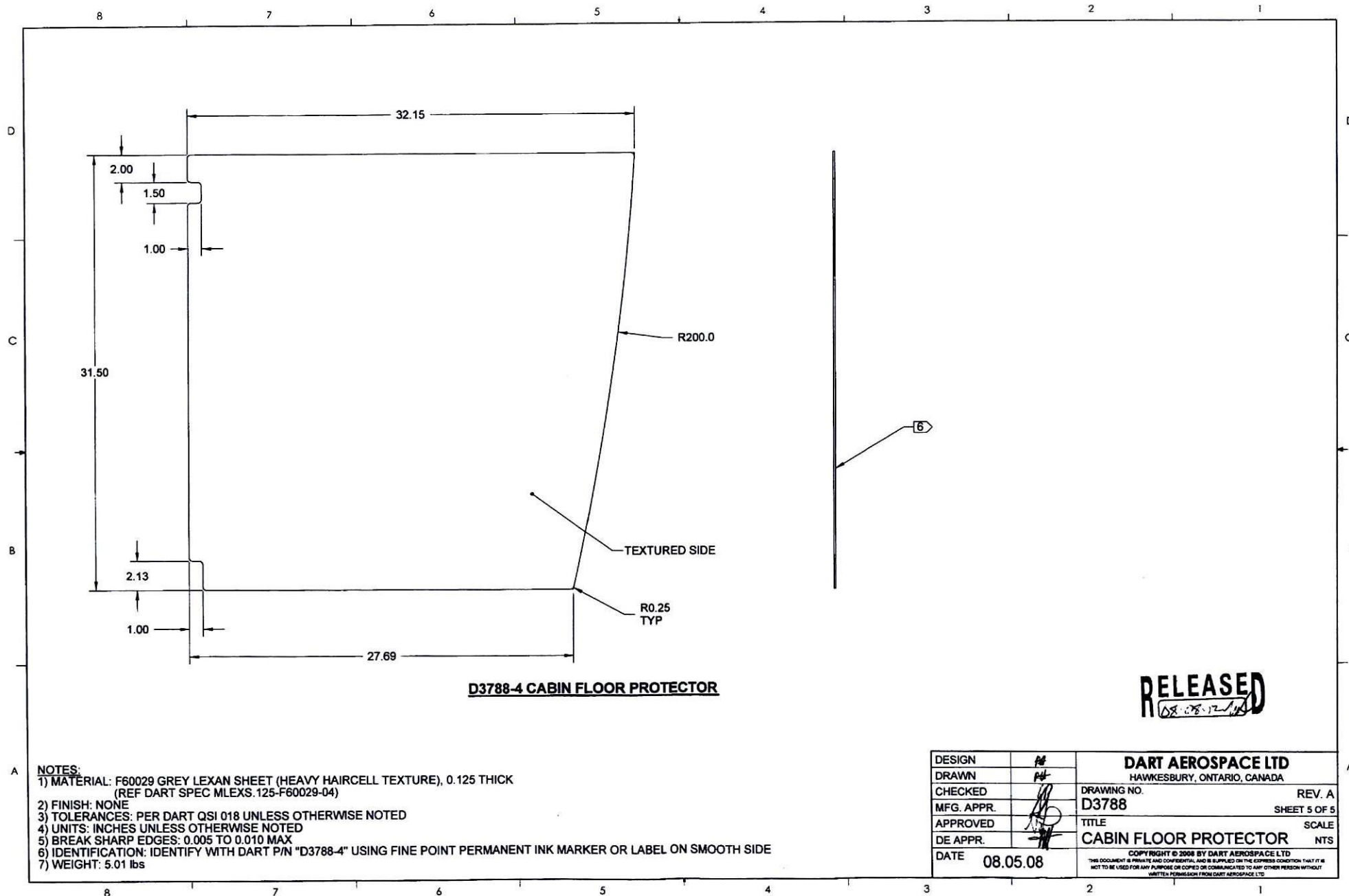
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Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
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